

## EDGE TREATMENT OF FLEXOGRAPHIC PRINTING PLATES

### Reference to Related Application

5   **[0001]**        This application claims the benefit of United States Patent Application Serial No. 60/416,249 filed 7 October 2002.

### Technical Field

10   **[0002]**        This invention relates to flexographic printing. Particular embodiments of the invention relate to apparatus and methods for preparing and imaging flexographic printing plates and treating the edges thereof.

### Background

15   **[0003]**        Printing plates used in flexographic printing typically comprise a photopolymer layer or some other photosensitive imageable layer. Traditionally, an image is applied to the printing plate by exposing the photopolymer layer to actinic radiation (e.g. ultraviolet (UV) flood radiation) with a UV-opaque image mask interposed between the radiation source and the printing plate. Because of the  
20   image mask, some regions of the photopolymer are exposed to the radiation while other regions of the photopolymer are not exposed. The exposure to actinic radiation changes the properties of the photopolymer in the exposed region, for example by cross-linking. After imaging, the plates are processed to remove either the exposed photopolymer regions  
25   or the unexposed photopolymer regions, thereby creating a relief-based image on the printing plate. The processed plates are then mounted on a printing press, where they are used to transfer ink to desired printing surface(s).

30   **[0004]**        Recently, it has become possible to prepare flexographic printing plates with an integral UV-opaque surface mask layer. Such UV-opaque surface mask layers are typically sprayed or roll-coated over

the photopolymer surface after the plate has been fabricated and then  
imagewise patterned to form a mask. Imagewise patterning may involve  
ablating or removing masking material from the plate or otherwise  
converting masking material between UV-transparent and UV-opaque  
5 states.

**[0005]** One type of integral UV-opaque surface mask layer is  
known as laser ablation mask system ("LAMS") layer. In operation,  
the UV-opaque LAMS layer is coated onto the top surface of the  
10 printing plate's photopolymer layer and is then selectively (i.e.  
imagewise) patterned. Patterning the LAMS layer typically involves  
selective laser ablation of the LAMS layer. Such laser radiation may be  
provided by infrared (IR) lasers on a laser imaging head which is part of  
a digital imaging device, for example. Regions of the LAMS layer  
15 which have been ablated in this manner become UV-transparent,  
creating a mask that is integral with the photopolymer layer of the  
printing plate. After ablating the LAMS layer to create the mask, the  
plate is exposed to actinic flood radiation. In regions where the LAMS  
layer has been ablated to become UV-transparent, the underlying  
20 photopolymer layer is exposed to the actinic radiation. Conversely, in  
regions where the LAMS layer has not been ablated and is still UV-  
opaque, the underlying photopolymer layer is not exposed. The  
exposure to actinic radiation changes the properties of the photopolymer  
in the exposed regions. The plates are then processed to create a relief-  
25 based image on the printing plate by removing the LAMS layer and  
either the exposed or unexposed photopolymer regions. The processed  
plates may then be used in a printing press to transfer ink to desired  
printing surface(s).

30 **[0006]** Further advances in the art have made it possible to provide  
many plate preparation procedures "in the round" (i.e. on the

cylindrical surface of a drum rather than on a flat two-dimensional surface). Such “in the round” procedures may involve, for example, applying a surface mask layer to the photopolymer layer of a printing plate, imagewise ablating or otherwise imagewise patterning the surface mask layer, exposing the masked plate to actinic flood radiation and subsequent processing.

[0007] In order to perform these types of plate preparation procedures “in the round”, it is desirable for the printing plates to be easily supported on the cylindrical surface of a drum. One technique, known as continuous photopolymer sleeve (“CPPS”), involves providing a seamless cylindrical tube of photopolymer (a “CPPS plate”). The tubular CPPS plate may be mounted on the drum of a plate preparation device and/or a printing press by sliding the tubular CPPS plate axially over the cylindrical surface of the drum. The inner diameter of the tubular CPPS plate is typically sized for a snug fit on the cylindrical surface of the drum.

[0008] CPPS plates suffer from a number of limitations. It is difficult to fabricate seamless CPPS plates, making them relatively expensive in comparison to conventional flat printing plates. CPPS plates are inefficient to transport, because the tubular-shaped CPPS plates occupy a large volume for the amount of printable surface area which they provide. Handling of CPPS plates is difficult, particularly after the sensitive LAMS layer (or other surface mask layer) has been applied. The use of CPPS plates may also be inefficient where an image to be printed occupies only a small region of the CPPS plate.

[0009] In an alternative technique known as “plate-on-sleeve”, one or more sections of initially flat printing plate are cut to size and then applied to (i.e. wrapped around) the cylindrical surface of a tubular

sleeve. Such tubular sleeves may be made from a variety of materials known in the art. Typically, the one or more sections of printing plate are mounted on the cylindrical surface of the tubular sleeve using a specialized plate-on-sleeve plate mounting apparatus. The one or more  
5 plate section(s) may be fastened to the tubular sleeve by any of a wide variety of techniques known in the art. The tubular sleeve bearing the one or more sections of printing plate may be mounted on the cylindrical drum of a plate preparation device and/or a printing press by sliding the tubular sleeve axially over the cylindrical surface of the  
10 drum. The inner diameter of the tubular sleeve may be sized for snug fit on the cylindrical surface of the drum.

**[0010]** Plate-on-sleeve preparation of printing plates has a number of advantages over CPPS techniques. Plate-on-sleeve printing plates  
15 may be fabricated and transported as flat sheets which may be subsequently cut or otherwise divided into appropriately sized plate section(s) and applied to the tubular sleeve, reducing fabrication and transportation costs. Once the plate section(s) are mounted on the tubular sleeve, non-plate bearing regions of the sleeve may be used for  
20 handling. In addition, the printing plate section(s) may be sized to fit the images being printed, maximizing the efficiency of plate usage.

**[0011]** One difficulty common to all techniques for preparing flexographic printing plates having LAMS layers or other types of  
25 integral surface masks occurs at the edges of the plate. Figure 1-A shows a printing plate **10** having a base layer **11**, a photopolymer layer **12** and an integral surface mask layer **14**. Surface mask layer **14** may be a LAMS layer, for example. In the illustration of Figure 1-A, surface mask layer **14** has already been imagewise patterned (for  
30 example, by selective ablation) to create a mask having UV-transparent regions **16** and UV-opaque regions **18**. UV radiation source **20**

produces a flood illumination field, schematically depicted by arrows 22. Actinic radiation field 22 exposes the areas of photopolymer layer 12 under UV-transparent mask regions 16, while the areas of photopolymer layer 12 located under UV-opaque mask regions 18 are not exposed. The exposure to actinic radiation changes the properties of photopolymer layer 12 in the exposed regions.

[0012] Figure 1-A shows that surface mask layer 14 (which has been sprayed or roll coated onto the top of photopolymer layer 12) does not cover the peripheral edges 27 of plate 10. While arrows 22, which schematically depict the flood actinic radiation field, are shown as perpendicular to the surface of printing plate 10, those skilled in the art will appreciate that the flood radiation also spreads laterally from UV source 20, as shown by arrows 24. As a result of this spreading, actinic radiation 24 incident on unmasked edges 27 of plate 10 at least partially exposes edge regions 26 of photopolymer layer 12. The exposure of edge regions 26 at least partially changes the properties of the photopolymer therein.

[0013] After UV exposure, printing plate 10 is processed, to produce the plate 10 shown in Figure 1-B. Processing typically involves the use of solvents and/or other procedures to remove LAMS layer 14. In the illustrated embodiment, processing also involves removing the unexposed regions of photopolymer layer 12 to form recessed regions 28. As shown in Figure 1-B, recessed regions 28 are formed where photopolymer layer 12 was masked by the UV-opaque mask regions 18 of LAMS layer 14. In practice, there may be a base level 30 of photopolymer layer 12 which is formed, for example, by prior UV exposure (not shown) originating from the underside of plate 10. Processing does not remove photopolymer from regions 29, where photopolymer layer 12 has been exposed. As a result, regions 29

provide relief with respect to base level 30 in regions 28. When subsequently used in a printing press (not shown), ink is applied to the upper surface of plate 10. Because of their relative relief, ink applied to regions 29 is transferred to the material being printed, whereas ink  
5 applied to recessed regions 28 is not transferred.

[0014] The exposure of edge regions 26 to actinic radiation 24 results in the formation of ridges 32 (Figure 1-B). Ridges 32 cause problems because they are not part of the desired image and when  
10 ultimately used in a printing press, ink applied to ridges 32 may be undesirably transferred to the material being printed.

[0015] In conventional (i.e. flat) preparation of flexographic plates, ridges 32 may be trimmed before the plate is mounted on the  
15 cylindrical drum of a printing press. However, ridges 32 present a particular difficulty when printing plates are prepared "in the round", because it is difficult to trim ridges 32 from CPPS plates or from plate section(s) which have already been affixed to a sleeve in a plate-on-sleeve process.

20 [0016] US Patent No. 6,326,124 (Alince et al.) describes a UV-opaque edge covering material which may be manually brushed or sprayed onto the edges of a printing plate prior to UV exposure to reduce the occurrence of ridges. Other known techniques involve the  
25 manual application of UV-opaque tapes or strips to the edges of plates prior to exposure.

[0017] There is a general need to reduce or eliminate ridges and/or similar effects which occur at the edges of flexographic printing plates  
30 during plate preparation. There is a particular need for automated apparatus and methods for accomplishing this objective.

Summary of the Invention

**[0018]** One aspect of the invention provides a method for preparing a flexographic printing plate having a photosensitive imageable layer. The method involves mounting the printing plate on a cylindrical drum. While the printing plate is on the drum, the method comprises: applying a surface mask layer to the printing plate, such that the surface mask layer masks the surface of the photosensitive imageable layer; applying an edge masking layer to at least one edge of the printing plate, such that the edge masking layer masks at least a portion of at least one edge of the photosensitive imageable layer; and patterning the surface mask layer. Applying an edge masking layer is performed in response to data. Such data may include: image data; format data; data relating to one or more dimensions of the printing plate; data relating to one or more edge locations of the printing plate; data relating to one or more dimensions of the photosensitive imageable layer; and data relating to one or more edge locations of the photosensitive imageable layer.

**[0019]** Both the surface mask layer and the edge masking layer may be formed from a material having the same composition. Applying the surface mask layer to the printing plate and applying the edge masking layer to the at least one edge of the printing plate may be performed in a single operation.

**[0020]** After application of the edge masking layer, the method may involve irradiating the edge masking layer to form an edge mask area. Patterning the surface mask layer may involve imagewise irradiating the surface mask layer.

**[0021]** The printing plate may comprise a continuous photopolymer sleeve or one or more plate sections applied to a tubular sleeve.

5 **[0022]** The method may also involve exposing at least a portion of the photosensitive imageable layer to actinic radiation, which may be preformed while the printing plate is on the drum or after the printing plate has been removed from the drum. After exposing at least a portion of the photosensitive imageable layer to actinic radiation, the  
10 method may involve removing portions of the photosensitive imageable layer to form a relief image.

**[0023]** The edge(s) of the photosensitive imageable layer may have a bevelled profile with a bevel angle of less than 90°. The method may  
15 comprise cutting the bevelled profile on an automated cutting table in accordance with format data supplied to a controller associated with the automated cutting table.

**[0024]** The edge masking material and/or the surface masking  
20 material may comprise a negative working material, which may contain carbon. Alternatively, the edge masking material and/or the surface mask material may comprise a positive working material which may require radiation to make the mask opaque to actinic radiation. In the further alternative, the surface mask layer may comprise a positive  
25 working material and the edge masking layer may comprise a negative working material.

**[0025]** The method may involve determining, based on format data associated with the printing plate, at least one of: the data relating to one  
30 or more edge locations of the photosensitive imageable layer; the data relating to one or more dimensions of the photosensitive imageable



layer; the data relating to one or more edge locations of the printing plate; and the data relating to one or more dimensions of the printing plate. Additionally or alternatively, the method may involve determining the same types of data using an edge detection sensor. The  
5 edge detection sensor may comprise at least one of: an optical sensor; an imaging sensor; a capacitive probe; and a physical contact-based edge detector.

[0026] Another aspect of the invention provides a method for  
10 preparing a flexographic printing plate. The method involves mounting one or more plate sections comprising photopolymer layers to a tubular sleeve and mounting the tubular sleeve with the mounted plate sections onto a cylindrical drum. While the sleeve is on the drum and in response to data provided by a controller, an edge masking layer is  
15 applied to the one or more plate sections for masking one or more edges of the photopolymer layers associated with the one or more plate sections.

[0027] The one or more plate sections may comprise an integral  
20 surface mask layer. Alternatively, the method may involve applying a surface mask layer to printing areas of the one or more plate sections. The surface mask layer may be applied to the printing areas of the one or more plate sections while they are on drum.

[0028] Another aspect of the invention provides a method for  
25 preparing a flexographic printing plate. The method involves mounting a printing plate comprising a photopolymer layer on a cylindrical drum. While the printing plate is on the drum and in response to data provided by a controller, the method comprises imagewise applying a patterned  
30 surface mask layer to a printing area of the printing plate and applying

an edge masking layer to the printing plate for masking one or more edges of the photopolymer layer.

5   **[0029]**       Applying the edge masking layer to the printing plate may comprise ejecting liquid from one or more inkjet nozzles.

10   **[0030]**       Another aspect of the invention provides a method for preparing a flexographic printing plate. The method involves mounting a printing plate comprising an integral surface mask layer and a photopolymer layer on a cylindrical drum. While the printing plate is on the drum and in response to data provided by a controller, an edge masking layer is applied to the printing plate for masking at least one edge of the photopolymer layer and the integral surface mask layer is patterned.

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20   **[0031]**       Another aspect of the invention provides a method for preparing a flexographic printing plate, the method involves mounting the printing plate on a cylindrical drum, providing a spray head comprising one or more spray nozzles for spraying edge masking material toward the drum and providing a controller connected to control relative movement between the spray head and the drum. Information is received at the controller from which locations of one or more edges of the printing plate are determinable. While the printing plate is on the drum and in response to the information received at the controller, the method comprises providing controlled relative movement between the spray head and the drum and spraying edge masking material from the one or more spray nozzles onto the one or more edges of the printing plate.

30   **[0032]**       The method may involve bevelling the edges of the printing plate prior to mounting the printing plate on the drum.

**[0033]** Another aspect of the invention provides an apparatus for applying an edge masking material to edges of a printing plate. The apparatus comprises a drum for supporting a printing plate on a cylindrical surface thereof, a spray head having one or more spray nozzles oriented to spray an edge masking material toward the drum and one or more actuators for providing relative movement between the spray head and the drum. A controller is connected to receive information from which locations of one or more edges of the printing plate are determinable. In response to the information, the controller is configured to provide suitable control signals to the one or more actuators for controlled relative movement between the spray head and the drum and to provide suitable control signals to the one or more spray nozzles to cause the one or more spray nozzles to spray edge masking material onto the one or more edges of the printing plate.

**[0034]** The one or more edges of the printing plate may comprise a bevelled profile.

**[0035]** The moveable spray head may comprise one or more spray nozzles for spraying a surface mask material toward the drum. The controller may be configured, in response to the information received at the controller, to provide controlled relative movement between the spray head and the drum by providing a suitable control signal to the one or more actuators and to spray a surface mask material from the one or more spray nozzles onto an imageable surface of the printing plate.

**[0036]** The surface mask material may be the same as the edge masking material and the one or more spray nozzles for spraying the surface mask material may be the same as the one or more spray nozzles for spraying the edge masking material.

**[0037]** The apparatus may also comprise a mounting table for supporting the printing plate and a pressure roller. The pressure roller and the drum may be rotatable about their respective elongated axes and  
5 movable to positions adjacent an edge of the mounting table where a leading edge of the printing plate may be made to project between the pressure roller and the drum, such that rotation of the pressure roller and the drum draws the printing plate from the mounting table and onto the cylindrical surface of the drum.

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**[0038]** The apparatus may comprise a tubular sleeve supported on the cylindrical surface of the drum and interposed between the cylindrical surface and the printing plate.

15 **[0039]** The apparatus may comprise a tubular sleeve mounted on the cylindrical surface of the drum and means for mounting the printing plate on the tubular sleeve.

**[0040]** Further aspects and features of specific embodiments of the  
20 invention are described below.

#### Brief Description of the Drawings

**[0041]** In drawings, which illustrate non-limiting embodiments of the invention:

25 Figure 1-A is a schematic illustration depicting a printing plate being imaged according to a typical prior art plate preparation process;

Figure 1-B is a schematic illustration of the printing plate of Figure 1-A after processing;

30 Figure 2-A is a schematic sectional view of a mask application apparatus according to a particular embodiment of the invention;

Figure 2-B is an enlarged partial view of the printing plate of Figure 2-A;

Figure 2-C is a schematic cross-sectional depiction of a spray nozzle and its spray pattern;

5        Figure 2-D is a schematic partial cross-sectional view of a number of example bevelled edge profiles suitable for use in accordance with the invention;

10       Figure 3 is a schematic isometric view of a combined mask application/plate patterning apparatus according to a particular embodiment of the invention;

Figure 4 is a schematic isometric view of a combined mask application/plate mounting apparatus according to a particular embodiment of the invention;

15       Figure 5-A is a schematic sectional view of a mask application apparatus according to an alternative embodiment of the invention;

Figure 5-B is a schematic cross-sectional view of a spray nozzle of the Figure 5-A apparatus configured for spraying a first spray pattern;

20       Figure 5-C is a schematic cross-sectional view of a spray nozzle of the Figure 5-A apparatus configured for spraying a second spray pattern;

Figure 5-D is a schematic cross-sectional view of a spray nozzles having a non-orthogonal orientation; and,

25       Figure 6 is a schematic sectional view of a mask application apparatus according to a further alternative embodiment of the invention.

### Description

30       [0042]       Throughout the following description, specific details are set forth in order to provide a more thorough understanding of the invention. However, the invention may be practised without these

particulars. In other instances, well known elements have not been shown or described in detail to avoid unnecessarily obscuring the invention. Accordingly, the specification and drawings are to be regarded in an illustrative, rather than a restrictive, sense.

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- [0043]** This invention involves automated apparatus and methods for preparing flexographic printing plates by applying masking material to the edges of photosensitive layers (e.g. photopolymer layers) of printing plates. To simplify the language of this description and the accompanying claims, plate(s), printing plate(s) and printing plate section(s) should be interpreted to include, without limitation, unprepared and partially prepared printing plate precursor(s) and printing plate element(s) regardless of their type and regardless of their state of preparation, as well as more fully prepared printing plate(s).
- 10 Such plate(s) typically include a photosensitive imageable layer which may be a photopolymer layer or the like. The plate(s) may be CPPS plates and/or plate section(s) mounted on a sleeve in a plate-on-sleeve process.
- 15
- [0044]** In accordance with the invention, the masking material is applied to the edges of the plates by one or more spray nozzle(s) located on a spray head. Preferably, relative movement between the spray head and the printing plate is provided and the nozzle(s) are activated/deactivated in response to data supplied by a controller. More
- 20 specifically, the controller is provided with information regarding the location of the edges of the printing plates. In response to that information, the controller may cause the spray head to travel along the edges while the nozzle(s) spray masking material onto the edges. Additionally or alternatively, the controller may control the movement
- 25 of the spray head to apply a surface mask (for example, by line traversal or helical traversal) and may use the location of the edges to control the
- 30

spray nozzle(s), activating the spray nozzle(s) to apply masking material on the surface and edges of the plates, and deactivating the spray nozzle(s) when the spray head moves over a region not occupied by a plate or a plate edge. The controller may use other techniques to apply  
5 masking material to the edges of a printing plate in response to edge location information.

**[0045]** The edges of the printing plate(s) may be provided with a bevelled profile which facilitates application of sprayed masking  
10 material. Additionally or alternatively, the nozzle(s) located on the spray head may be configured for expulsion of a widely diverging spray pattern or the spray nozzle(s) may be oriented to aim their spray pattern(s) at a non-orthogonal angle relative to the printing plate. Such spray pattern(s) may be used for application of masking material to  
15 perpendicular (i.e. non-bevelled) edges of printing plates. Selective coating heads comprising inkjet nozzle(s) may also be used for imagewise application of masking material to the surfaces and/or edges of printing plates. Advantageously, this invention may involve integrating edge coating spray heads into other flexographic plate  
20 preparation apparatus, such as a mask application device, a combined mask application/plate patterning device, or, in the case of a plate-on-sleeve process, a combined mask application/plate mounting device.

**[0046]** Figure 2-A shows a schematic sectional view of a printing  
25 plate mask application apparatus 35 according to a particular embodiment of the invention. Mask application apparatus 35 comprises a cylindrical drum 40 which is rotatable about its elongated axis 42. Drum 40 supports a photopolymer-based printing plate 44 on its cylindrical surface. In the illustrated embodiment, printing plate 44 has  
30 been affixed to a tubular sleeve 41 in a plate-on-sleeve process. Plate 44 may have been previously mounted onto sleeve 41 using a plate-on-

sleeve plate mounting apparatus (not shown). Although not shown in Figure 2-A, those skilled in the art will appreciate that more than one section of printing plate **44** may be mounted on sleeve **41**, as is typical in a plate-on-sleeve process. Drum **40** of mask application device **35**  
5 may also accommodate seamless CPPS plates.

[0047] In the illustrated embodiment, edges **54** of plate **44** are bevelled with a straight angular profile having a bevel angle  $\alpha$  (see Figure 2-B). Preferably, bevel angle  $\alpha$  is less than  $90^\circ$  from a plane  
10 tangential to the imageable surface of plate **44**. Bevel angle  $\alpha$  may be in the range between  $20^\circ$ - $80^\circ$ . The bevel of edges **54** is preferably provided prior to mounting plate **44** onto sleeve **41**. Edges **54** may be fabricated to have a bevelled profile. Edges **54** may also be cut to provide a bevelled profile using an automated cutting table (not shown)  
15 as described in commonly assigned Canadian Patent Application No. 2,359,259 (Salvestro), which is hereby incorporated by reference. The cutting of edges **54** may be performed in response to format data supplied to a cutting table controller. Such format data may indicate the particular bevel angle  $\alpha$  of any angled cut to be performed.

20

[0048] As shown in Figure 2-A, mask application device **35** comprises a spray head **46** which is moveable in a direction parallel with axis **42** upon a pair of tracks **48**. In the illustrated embodiment, a lead screw (not shown) extends through threaded aperture **50**, such that  
25 rotation of the lead screw causes axial movement of spray head **46** upon tracks **48**. Other linear actuation devices may be used to provide axial movement of spray head **46**.

[0049] As spray head **46** moves axially and drum **40** rotates about  
30 its axis, one or more suitably oriented spray nozzle(s) **52** apply an integral surface mask layer **55** (Figure 2-B) to the outer surface of plate



**44.** A schematic cross-sectional representation of a spray nozzle **52** and its spray pattern **74** is shown in Figure 2-C. Spray pattern **74** has a central axis **74A** and a divergence angle  $\theta$ . Preferably, but not necessarily, divergence angle  $\theta$  is within a range of 20°-120°. Spray nozzle **52** is preferably oriented such that central axis **74A** is substantially orthogonal to the imageable surface of printing plate **44** (i.e. the cylindrical surface of drum **41**). In alternative embodiments discussed further below, spray nozzle **52** may be oriented such that central axis **74A** is non-orthogonal to the imageable surface of plate **44**.

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**[0050]** As spray head **46** moves axially and drum **40** rotates about its axis, spray nozzle(s) **52** apply a surface mask layer **55** (Figure 2-B) to the outer surface of plate **44**. Surface mask layer **55** may be applied by spray head **46** and nozzle(s) **52** as described in commonly assigned US Patent No. 6,180,325 (Gelbart), which is hereby incorporated by reference. For example, surface mask layer **55** may be applied in a helical pattern wherein drum **40** rotates at the same time as spray head **46** moves axially. As an alternative example, surface mask layer **55** may be applied in a line traversal pattern wherein spray head **46** moves axially over the surface of printing plate **44** to spray a first line (i.e. a line traversal) and then drum **40** rotates by a small amount whereupon spray head **46** makes another axial line traversal. Surface mask layer **55** may be a LAMS layer. Surface mask layer **55** may alternatively comprise other types of masking materials which may be patterned by other patterning techniques.

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**[0051]** As shown in Figure 2-B, spray nozzle(s) **52** of spray head **46** also spray an edge masking layer **60** over bevelled edges **54** of plate **44**. The bevelled profile of edges **54** ensures that edge masking layer **60** applied by spray nozzle **52** adequately coats edges **54**.

30

**[0052]** Edge masking layer **60** and surface mask layer **55** preferably comprise a material having the same composition, so that surface mask layer **55** and edge masking layer **60** may be applied by the same nozzle(s) **52** in a single operation. For example, if surface mask layer **55** is applied according to a line traversal process, then surface mask layer **55** and edge masking layer **60** may be applied to plate **44** in a single line traversal of spray head **46**. Spray head **46** may also make several traversals of plate **44** (both axial and circumferential) to apply surface mask layer **55** and/or edge masking layer **60**. Spray head **46** may also dwell over edges **54** to ensure that a sufficient amount of edge masking material is sprayed to form edge masking layer **60**.

**[0053]** When implemented as a LAMS layer, surface mask layer **55** and edge masking layer **60** are UV-opaque, IR-absorbing material(s). For example, edge masking layer **60** may comprise a mixture of carbon black and a suitable binder in an organic or aqueous solvent. Carbon black is advantageous, because it is opaque to UV radiation and absorbs IR patterning radiation. In some cases, it may be advantageous to apply one or more intermediate layer(s) (not shown) in between the photopolymer layer of plate **44** and surface mask layer **55** and/or edge masking layer **60**. Such intermediate layer(s) may prevent surface mask layer **55** and/or edge masking layer **60** from interacting with the photopolymer layer on plate **44**.

**[0054]** The relative movement of spray head **46** and drum **40** and the activation/deactivation and/or spray rate of nozzle(s) **52** is preferably controlled by controller **56** which may comprise one or more suitably programmed embedded processor(s), external processor(s), computer(s) or the like. In order to effect such control, controller **56** may be provided with information regarding the location, size and shape of plate **44**, the image(s) to be applied to plate **44**, format data regarding

plate **44** and the images to be recorded thereon and the like. Format data may include, without limitation, the size of the image, the size of the plate, relationships between the size of the image and the size of the plate, the location(s) of one or more images on the plate, the location(s)  
5 of one or more plates on the drum and the like.

**[0055]** Controller **56** is provided with information regarding the location of edges **54** of plate **44**, which it uses to apply edge masking layer **60**. For example, controller **56** may be programmed with  
10 software that determines or reads where an image is to be formed on a particular printing plate and determines a pattern for the desired application of surface mask layer **55** and/or edge masking layer **60**. Such software may determine where the edges of a plate are relative to the image and then cause the application of edge masking layer **60** in a  
15 pattern which comprises the area between the edges **54** of plate **44** and the edge of the image (not shown).

**[0056]** In alternative embodiments, mask application apparatus **35** may be equipped with an edge detection system (not shown) which  
20 provides edge location information to controller **56**. Edge detection systems may generally comprise any type of edge detectors, such as optical edge detectors, imaging edge detectors, capacitive probes and/or physical contact-based edge detectors, for example. In a plate-on-sleeve precess where multiple printing plate sections (not shown) are mounted  
25 on sleeve **41**, controller **56** may also be provided with similar information in respect of each or any of the plate sections.

**[0057]** Controller **56** uses edge information to apply edge masking layer **60** by controlling the relative movement of spray head **46** and  
30 drum **40** and/or the activation of nozzle(s) **52**. In one embodiment, controller **56** uses edge information to cause spray head **46** to

controllably travel along edges **54** while nozzle(s) **52** spray masking material onto edges **52**. The controlled movement of spray head **46** along edges **54** may be caused, for example, by linear actuation of spray head **46**, rotation of drum **40** or some combination thereof. Controller **56** may also control the rate of travel of spray head **46** and/or the spray rate of nozzle(s) **52** to achieve desired properties (e.g. thickness) of edge masking layer **60**.

**[0058]** In an alternative embodiment, controller **56** controllably moves spray head **46** to apply a surface mask (for example, by line traversal or helical traversal) and uses edge location information to control the activation of spray nozzle(s) **52**. Controller **56** may activate spray nozzle(s) **52** to apply masking material on the surface and edges **54** of plate **44**, and may deactivate spray nozzle(s) **52** when spray head **56** moves over a region not occupied by plate **44** or its edges **54**. Once again, controller **56** may control the rate of travel of spray head **46** and/or the spray rate of nozzle(s) **52** to achieve desired properties of edge masking layer **60**. For example, controller **56** may cause spray head **46** to dwell for a period of time over edges **54** to achieve a desired thickness of edge masking layer **60**.

**[0059]** Mask application apparatus **35** may also comprise an optional drying unit (not shown) to dry surface mask layer **55** and/or edge masking layer **60** after application. The drying unit may comprise a fan, a nozzle connected to a source of compressed gas and/or a heater, for example.

**[0060]** After application of surface mask layer **55** and edge masking layer **60**, plate **44** is patterned. Patterning may be performed in a separate patterning apparatus (not shown). When surface mask layer **55** is a LAMS layer, the patterning apparatus comprises an

imaging head with one or more selectively actuatable patterning lasers. These selectively actuatable patterning lasers, which may be IR lasers, imagewise ablate certain regions of surface mask layer 55 to remove the material of surface mask layer 55 from these regions or to otherwise  
5 make these regions UV-transparent. Flood actinic illumination is then applied to plate 44, exposing the photopolymer which underlies the UV-transparent regions of surface mask 55. Since edges 54 of plate 44 are coated with edge masking layer 60, the actinic illumination does not expose the photopolymer underlying edges 54. Plate 44 is then  
10 processed to remove the surface mask layer 55, the edge masking layer 60 and either the exposed or non-exposed regions of the photopolymer layer. Since edges 54 of plate 44 were not exposed to actinic radiation, there are no ridges or similar edge effects on plate 44. Plate 44 may then be mounted on the drum of a printing press to transfer the image  
15 imparted thereon to desired printing surface(s).

[0061] In the illustrated embodiment of Figures 2-A and 2-B, bevelled edges 54 are axial edges which extend substantially parallel to the axis 42 of drum 40. Edges of plate 44 having other orientations,  
20 such as circumferential edges (i.e. edges extending around the circumferential surface of drum 40) and/or skewed edges (i.e. edges that are neither axial or circumferential). In the illustrated embodiment, bevelled edges 54 are shown having a straight bevelled profile with a bevel angle  $\alpha$  with respect to the imageable surface of printing plate 44.  
25 Bevelled edges 54 may also have alternative profiles which expose edges 54 to spray from spray nozzle(s). Such bevelled edge profiles may be curved or may have a number of angular sections. A number of non-limiting examples of bevelled edge profiles 54A, 54B, 54C, 54D, 54E are depicted in Figure 2-D. Preferably, alternative embodiments of  
30 bevelled edge 54 have a profile wherein a tangent to the surface of bevelled edge 54 forms a bevel angle  $\alpha$  with the circumferential surface

of drum **40** and the bevel angle  $\alpha$  is less than  $90^\circ$ . Preferably, the bevel angle  $\alpha$  is within the range of  $20^\circ$ - $80^\circ$  over at least a majority of bevelled edge **54**. In some embodiments, bevelled edge **54** may only exist in the region of the photopolymer layer and other portions of the printing plate may have a conventional orthogonal edge profile.

**[0062]** Edge masking layer **60** and/or the surface mask layer **55** may comprise negative working material or positive working material. A mask layer comprising negative working material is conventionally UV-opaque after application to the printing plate. An imaging beam may then pattern the mask, rendering portions of the mask transparent to UV radiation or removing portions of the mask to expose the underlying photopolymer. After patterning the mask, the photopolymer layer of the printing plate may be exposed to actinic radiation to form a relief image on the plate. A mask layer comprising positive working material is conventionally UV-transparent after application to the printing plate. An imaging beam may then pattern the mask, rendering portions of the mask opaque to UV radiation. These opaque portions of the mask will block subsequently applied actinic radiation, but portions of the mask not exposed to patterning radiation remain transparent to actinic radiation and will allow the exposure of the underlying photopolymer to form a relief image on the plate.

**[0063]** In cases where edge masking layer **60** comprise positive working material, edge masking layer **60** is exposed to radiation to form a UV-opaque edge mask area. In addition, where surface mask layer **55** comprises a positive working material, surface mask layer **55** may be patterned by exposing portions of surface mask layer **55** to radiation. Patterning radiation sources which are normally used to pattern surface mask layer **55** (not shown in Figures 2-A, 2-B) may have to be refocused or otherwise adjusted to provide sufficient exposure to the

edges 54 of plate 44. Alternatively, different radiation sources may be used to expose edge masking layer 60 of plate 44 and to pattern surface mask layer 55.

5 [0064] Figures 5-A, 5-B and 5-C depict a mask application apparatus 65 according to an alternative embodiment of the invention, where edges 53 of photopolymer plate 44 are non-bevelled (i.e. substantially orthogonal to the imageable surface of plate 44). In mask application apparatus 65, spray head 46 comprises one or more variable  
10 spray nozzle(s) 70. Variable nozzle(s) 70 are configurable to provide different spray patterns 72, 74. As shown in Figure 5-B, nozzle 70 may be adjusted to provide a widely diverging spray pattern 72 having a divergence angle  $\theta_1$ . The wide divergence angle  $\theta_1$  of spray pattern 72 makes this configuration of variable nozzle(s) 70 suitable for spraying  
15 an edge masking material onto the non-bevelled edges 53 of plate 44. As shown in Figure 5-C, nozzle 70 may be adjusted to provide a relatively narrowly diverging spray pattern 74 having a divergence angle  $\theta_2$ . The narrow divergence angle  $\theta_2$  of spray pattern 74 makes this configuration suitable for spraying a surface mask onto plate 44 (Figure  
20 5-C) and for spraying an edge masking layer on a bevelled edge (not shown). However, as shown in dashed lines in Figure 5-C, the narrow divergence angle  $\theta_2$  of spray pattern 74 makes this configuration unsuitable for applying an edge masking material to non-bevelled edge 53. Mask application apparatus 65 of Figure 5-A otherwise comprises  
25 components and functionality that is substantially similar to that of mask application apparatus 35 shown in Figure 2-A and described above.

[0065] In further alternative embodiments, a spray head may comprise one or more nozzle(s) particularly configured for applying  
30 edge masking material to the plate edges. Such spray heads may be separate spray heads comprising only edge spraying nozzle(s) or such

spray heads may comprise one or more principal nozzle(s) for spraying a surface mask layer on a printing plate and/or one or more auxiliary edge spraying nozzle(s). In one example, a spray head may comprise one or more edge spraying nozzle(s) which spray a widely diverging spray pattern (similar to widely diverging spray pattern 72 of Figure 5-B) capable of coating a non-bevelled edge. In another example depicted schematically in Figure 5-D, a spray head may comprise one or more edge spraying nozzle(s) oriented such that the central axis 74A of their spray pattern(s) 74 is directed towards the printing plate at a non-orthogonal angle. Such angularly oriented edge spraying nozzle(s) may apply edge masking material to a non-bevelled edge. Preferably, such angularly oriented edge spraying nozzle(s) are oriented such that the central axis 74A of their spray patterns forms an angle in a range between 20°-80° with respect to the imageable surface of the printing plate. A spray head may comprise a plurality of edge spraying nozzles having a plurality of non-orthogonal orientations, such that they may apply edge masking material to plate edges having a number of different orientations. A spray head may also comprise one or more edge spraying nozzle(s) having adjustable orientations, such that the edge spraying nozzle(s) may be oriented at a plurality of desired angles with respect to the various plate edges for applying edge masking material to plate edges having a number of different orientations. These alternative embodiments may also be used to spray edge masking material onto bevelled printing plate edges.

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[0066] Figure 3 shows a combined mask application/plate patterning apparatus 110 in accordance with one embodiment of the invention. Apparatus 110 includes a drum 112 which is mounted for rotation about an axis 114 as indicated by arrow 116. A printing plate 118 is mounted on the cylindrical surface 112A of drum 112. Printing plate 118 comprises a base layer 188A and a photopolymer layer 118B.

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In the illustrated embodiment, printing plate **118** is a seamless CPPS plate, wherein base layer **118A** fits snugly onto the cylindrical surface **112A** of drum **112**. Drum **112** may also accommodate one or more sections of printing plate mounted on a sleeve in a plate-on-sleeve process. Head **120** is mounted on tracks **122** for movement in a direction parallel to axis **114** as indicated by arrow **124**. Axial movement of head **120** is actuated by rotation of lead screw **123**. Other linear actuation devices may be used to provide axial movement of head **120**.

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[0067] Printing plate **118** is initially mounted onto the cylindrical surface **112A** of drum **112** prior to application of a surface mask layer. Moveable head **120** includes a coating unit **126** which preferably comprises one or more spray nozzle(s) (not shown) for application of surface mask layer **140** onto photopolymer layer **118B**. Surface mask layer **140** may be applied to photopolymer layer **118B** in the manner described above and in commonly assigned patent United States Patent No. 6,180,325 (Gelbart).

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20 [0068] In addition to applying surface mask layer **140**, the spray nozzle(s) of coating unit **126** apply an edge masking layer (not shown) to the edges **125** of printing plate **118**. The spray nozzle(s) used for application of the edge masking layer may be the same spray nozzle(s) used for the application of surface mask layer **140** or they may be different spray nozzle(s). Preferably, as described above, edges **125** of plate **118** are provided with a bevelled profile, such that the edge masking layer applied by coating unit **126** adequately coats edges **125**. Coating unit **126** and its spray nozzle(s) may comprise any of the embodiments described above and may function as described above for application of edge masking material to edges **125** of printing plate **118**. A controller **147** may be provided with the same types of information

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and function in the same manner described above to control the relative movement of drum **112** and coating unit **126** and the activation and/or spray rate of the nozzles.

5    **[0069]**       In the illustrated embodiment of Figure 3, printing plate **118** is a seamless CPPS plate. Accordingly, the spray nozzle(s) of coating unit **126** apply the edge masking layer only to circumferential edges **125**. Where drum **112** supports one or more sections of printing plate mounted on a sleeve in a plate-on-sleeve process (not shown), the  
10   spray nozzle(s) of coating unit **126** apply the edge masking layer to all of the edges of the printing plate sections.

**[0070]**       In the illustrated embodiment, head **120** comprises an optional drying unit **134** to dry surface mask layer **140** and the edge  
15   masking layer after application. Drying unit **134** may comprise a fan, a nozzle connected to a source of compressed gas and/or a heater, for example.

**[0071]**       Head **120** of combined mask application/plate patterning  
20   apparatus **110** also comprises a patterning unit **132** used to selectively pattern surface mask layer **140**. Typically, patterning of surface mask layer **140** may involve creation of UV-transparent regions **144** within UV-opaque mask regions **142** or vice versa. In the case where surface mask layer **140** is a LAMS layer, patterning unit **132** comprises one or  
25   more IR lasers (not shown) which ablate surface mask layer **140** in regions **144**. Ablation removes surface mask layer in regions **144** to make these regions UV-transparent. Patterning unit **132** receives control signals from controller **147**. These control signals specify the locations of regions **142**, **144** and switches each laser on when the  
30   control signal indicates that the laser's beam is directed at a point in a region **144**. Where surface mask layer **140** is some other type of mask

layer, patterning unit **132** may comprise some other selectively actuatable device for converting surface mask layer **140** from UV-opaque to UV-transparent (or vice versa) in regions **142, 144**.

5    **[0072]**        In the illustrated embodiment, head **120** also comprises a UV illumination unit **136**. UV illumination unit **136** comprises at least one UV source **137** for exposing photopolymer layer **118B** to actinic radiation through the mask formed by the patterned regions **142, 144** of surface mask layer **140**. In the illustrated embodiment, combined mask  
10 application/plate patterning apparatus **110** also comprises an optional blanket cleaner **146** which may be used to remove surface mask layer **140** and the edge masking layer after UV exposure. In some embodiments, combined mask application/plate patterning apparatus **110** may not include UV illumination unit **136**. In such embodiments,  
15 photopolymer layer **118B** may be exposed to actinic radiation in a separate apparatus.

**[0073]**        Combined mask application/plate patterning apparatus **110** minimizes the handling of plate **118** by providing a single apparatus for:  
20 (i) the application of surface mask layer **140** and the edge masking layer by coating unit **126**; (ii) the selective (i.e. imagewise) patterning of surface mask layer **140** by patterning unit **132** to form UV-opaque and UV-transparent regions **142, 144**; and (iii) the UV exposure of patterned regions **142, 144** by UV illumination unit **136**. In particular, handling  
25 of plate **118** is minimized after application of surface mask layer **140** which may be particularly sensitive. Once plate **118** is exposed to actinic radiation from UV illumination unit **136**, surface mask layer **140** is no longer required, so any subsequent damage to surface mask layer **140** is inconsequential.

**[0074]** Figure 4 shows a combined mask application/plate mounting apparatus **150** for use in a plate-on-sleeve process. Apparatus **150** includes a frame **164** which supports cylindrical drum **158**, pressure roller **160** and table **156**. Cylindrical drum **158**, pressure roller **160** and table **156** are translatable within frame **164**. Cylindrical drum **158** and pressure roller **160** are also rotatable within frame **164** about their respective elongated axes. Apparatus **150** also comprises a spray head **155** which is moveable along tracks **152** in a direction parallel with the elongated axes of cylindrical drum **158** and pressure roller **160**.  
Movement of spray head **155** may be effected by a lead screw, for example, or by any other suitable linear actuator (not shown). Spray head **155** comprises one or more suitably oriented spray nozzles (not shown) for application of a surface mask layer and an edge masking layer to the various sections of printing plate **162**.

**[0075]** In operation, tubular sleeve **166** is mounted on drum **158** by sliding tubular sleeve **166** axially over the cylindrical surface of drum **158**. Preferably, the inner diameter of tubular sleeve **166** is sized for a snug fit on the cylindrical surface of drum **158**. One or more section(s) of printing plate **162** are positioned on an upper surface **157** of table **156**. Apparatus **150** preferably comprises a means for registering printing plate sections **162** on surface **157** of table **156**. Such registration means are well known in the art. Preferably, but not necessarily, the edges of printing plate section(s) **162** are provided with bevelled profile as described above prior to being mounted on table **156**.

**[0076]** Printing plate section(s) **162** are then loaded from table **156** onto tubular sleeve **166**. To load plate section(s) **162** onto sleeve **166**, drum **158** and pressure roller **160** are translated to positions adjacent to the leading edge **159** of table **156**. Table **156** is then retracted from

under plate section(s) **162** as drum **158** and pressure roller **160** are rotated in opposing angular directions about their respective elongated axes. As table **156** is retracted, the leading edge(s) of plate section(s) **162** are sandwiched between drum **158** and pressure roller **160**, such  
5 that the rotation of drum **158** and pressure roller **160** draws plate section(s) **162** from table **156** and causes plate section(s) **162** to wrap themselves around the cylindrical surface of sleeve **166**. The cylindrical surface of sleeve **166** may be provided with means for retaining plate sections **162** to the surface of sleeve **166**. Such plate retention means  
10 may include any of the plate retention techniques known in the art including, for example, clamping, electrostatic force, vacuum force, adhesive or the like. In some embodiments, pressure roller **160** may also function to remove a cover sheet from the upper surface of plate section(s) **162**.

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[0077] After loading plate section(s) **162** onto sleeve **166**, drum **158** is translated back down into the vicinity of spray head **155**. In the illustrated embodiment, plate section(s) **162** are loaded onto sleeve **166** prior to the application of a surface mask layer or an edge masking  
20 layer. Once plate section(s) **162** are loaded onto sleeve **166**, a surface mask layer (not shown) may be applied to the outer surface of plate section(s) **162** and/or an edge masking layer may be applied to the edges of plate section(s) **162** by the nozzle(s) of spray head **155**. In order to apply the surface mask layer and/or the edge masking layer, spray head  
25 **155** moves axially along tracks **152** while drum **158** rotates about its axis. Surface mask layer **140** may be applied to photopolymer layer **118B** in the manner described in above and in commonly assigned patent United States Patent No. 6,180,325 (Gelbart). Spray head **155** and its spray nozzle(s) may comprise any of the embodiments described  
30 above and may function as described above for application of edge masking material(s) to the edges of plate section(s) **162**. A controller

**167** may be provided with the same types of information and function in the same manner described above to control the relative movement of drum **158** and spray head **155** and the activation and/or spray rate of the spray nozzles.

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**[0078]** After mounting plate section(s) **162** onto sleeve **166** and applying the surface mask layer and the edge masking layer to plate section(s) **162**, sleeve **166** bearing plate section(s) **162** is removed from combination mask application/plate mounting apparatus **150**. Plate  
10 section(s) **162** are then patterned and further processed in one or more different apparatus to provide a relief image. After patterning and processing, sleeve **166** may be mounted on the cylindrical drum of a printing press so that the image(s) imparted onto plate section(s) **162** may be transferred to desired printing surface(s).

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**[0079]** Figure 6 depicts a selective mask application apparatus **85** according to one embodiment of the invention. In the illustrated embodiment, printing plate **87** is mounted on sleeve **81** in a plate-on-sleeve process. Sleeve **81** is supported on the cylindrical surface of  
20 drum **83**. As is common in a plate-on-sleeve process, additional sections of printing plate (not shown) may also be mounted on sleeve **81**. Drum **83** may also accommodate continuous CPPS plates (not shown). Instead of applying a uniform surface mask layer to plate **87** and then subsequently patterning the surface mask, selective coating  
25 head **80** of apparatus **85** forms a mask in a single step by imagewise applying a patterned masking material **84** to plate **87** only in desired locations.

**[0080]** Selective coating head **80** may comprise, for example, an  
30 inkjet printing head having one or more inkjet nozzle(s) **82**. Ink jet nozzle(s) **82** of selective coating head **80** are capable of precisely

ejecting droplets of masking material **84** at desired locations on the surface and on the edges **88** of plate **87**. Preferably, as shown in the illustrated embodiment and described above, edges **88** of plate **87** are provided with a bevelled profile to facilitate the application of masking material **84** to edges **88**.

**[0081]** Selective coating head **80** and inkjet nozzle(s) **82** are connected for communication with a controller **86**, which may comprise one or more embedded processor(s), external processor(s), computer(s) or the like. Controller **86** controls the relative movement of selective coating head **80** and drum **83** and also controls the selective application of masking material **84** by inkjet nozzle(s) **82**. Controller **86** may be provided with information regarding the location, size and shape of plate **87**, the image(s) to be applied to plate **87**, the format of plate **87** and the like. Controller **86** is provided with information regarding the location of edges **88** of plate **87**, which it uses to apply masking material **84** to edges **88**. As discussed above in relation to controller **56** of mask application apparatus **35**, such edge location information may be deduced by software programmed into controller **86** or by an edge detection system. Controller **86** functions to control the relative movement of drum **83** and selective coating head **80** and the activation/deactivation and/or masking material ejection rate of inkjet nozzle(s) **82**.

**[0082]** Controller **86** is also provided with information about the image(s) to be applied to plate **87**, which it uses to control the imagewise application of masking material **84**. Selective coating head **80** and its inkjet nozzle(s) **82** receive control signals from controller **86** which specify the locations at which masking material **84** is to be applied to plate **87**. Inkjet nozzle(s) **82** are thus activated in regions

where masking material **84** is to be applied and deactivated in regions where no masking material **84** is required.

**[0083]** When used in a plate-on-sleeve process where multiple  
5 printing plate sections are mounted on drum **83**, controller **86** may also be provided with information similar to that described above in respect of each of the plate sections.

**[0084]** After the imagewise application of masking material **84** to  
10 the surface and edges **88** of plate **87**, actinic flood radiation is applied to plate **87** to expose the unmasked photopolymer regions. Plate **87** is then processed to remove the masking material and either the exposed or unexposed photopolymer regions. These plate preparation procedures may be performed by components (not shown) that form part of mask  
15 application apparatus **85** or in by one or more different apparatus. After processing, plate **87** is transferred to a printing press where it may be used to transfer ink to desired printing surface(s).

**[0085]** Components of selective coating apparatus **85** may be  
20 provided within a combined mask application/plate patterning apparatus similar to that of Figure 3. In particular, coating unit **126** may be replaced with selective coating head **80**. When selective coating head **80** is used for the imagewise application of masking material to desired areas of the printing plate, there is no need for subsequent patterning of  
25 the masking layer and no separate patterning unit **132** is required.

**[0086]** Components of selective coating apparatus **85** may also be provided in a combined mask application/plate mounting apparatus similar to that of Figure 4. In particular, mask application head **155**  
30 may be replaced with selective coating head **80**. When selective coating head **80** is used for the imagewise application of masking material to



desired areas of the printing plate on the plate mounting apparatus, there is no need for subsequent patterning of the masking layer and no separate patterning apparatus is required.

5   **[0087]**       As will be apparent to those skilled in the art in the light of the foregoing disclosure, many alterations and modifications are possible in the practice of this invention without departing from the spirit or scope thereof. For example:

- 10   •     In accordance with any of the above-described embodiments:
  - the surface mask layer and the edge masking layer may be applied by different spray heads or by different nozzles on the same spray head;
  - 15   •     the edge masking layer may comprise the same material used for the surface mask layer or, alternatively, the edge masking layer may comprise a different material such as the material described in US Patent No. 6,326,124 (Alince et al.); and,
  - 20   •     the edge masking layer and/or the surface mask layer may be formed from a number of constituent materials, each of which may have a separate spray nozzle.
- In alternative embodiments of the invention, it is not necessary to provide an edge masking layer that coats the entire edge of a printing plate. For example, it may be sufficient to coat only the edge(s) of the photosensitive layer (e.g. the photopolymer layer),  
25   rather than the entire edge of the printing plate. In other embodiments, it may be sufficient to coat only a top portion of the edge of the photopolymer layer with edge masking material, leaving a bottom portion of the photopolymer layer edge to be  
30   exposed by UV flood radiation. Because of the lack of an edge masking layer on the bottom portion of the photopolymer layer

edge, small ridges may be formed in edge regions of the photopolymer layer. However, these small ridges would be located only in the bottom portion of the photopolymer layer adjacent the unmasked bottom edge portions. As a result, the processed plate is still able to provide sufficient relief to avoid transferring ink from these ridges to the desired printing surface.

- 5       • In further alternative embodiments of the invention, a “page-wide” spray head may be provided with spray nozzles to apply edge masking material to the edges of printing plates. A page-  
10       wide spray head has an array of nozzles that spans the axial dimension of the drum. In such embodiments, it may not be necessary to move the spray head, as rotation of the drum is sufficient to provide complete coverage of the printing plate(s) mounted thereon.
- 15       • A number of the embodiments described above involve the edge treatment apparatus and methods of the present invention integrated with other flexographic plate preparation apparatus, such as: a mask application device (Figure 2-A); a combined  
20       mask application/plate patterning device (Figure 3); and a combined mask application/plate mounting device (Figure 4)). While it may be advantageous to integrate the edge treatment apparatus and methods of the present invention with these other plate preparation devices, edge treatment may also be performed within a separate apparatus or as part of a separate plate  
25       preparation process.
- Surface and edge masking layers other than a LAMS layer may be used in accordance with the principles of the invention. The surface and edge masking layers may comprise other types of mask materials having optical characteristics which may be  
30       selectively altered by exposure to, for example, laser radiation. For example, surface and edge masking layers may comprise

thermally sensitive coatings, such as Thermal Dry Silver™ sold by 3M of Minneapolis, Minnesota. This thermally sensitive coating is initially UV-transparent, but becomes UV-opaque when exposed to heat.

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**[0088]** Accordingly, the scope of the invention is to be construed in accordance with the substance defined by the following claims.